

Work Order ID 136047

Monday, September 14, 2015 2:44:37 PM

Page 1

Item ID: D350-636-047

Accept

136047

Revision ID:

N900040100

Setup Start

NS1

Item Name: Run-on Landing Wearplates Fits LH or RH

Stop

NS2

Start Date: 8/27/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/28/2015 Req'd Qty: 2.00

2

Customer: CHNET01

Reference: RMA RA112119

Approvals: Process Plan: mf

Date: 15-9-14

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D350-636

J

100

0.00

100

QC

Quality Control

Memo

0.00

INSPECT RA112119 D350-636-047 X 2 B130718

KITS CAME BACK AND WEARPLATES ARE SCRAP

RETURN PARTS AND HARDWARE UNDER ORIGINAL BATCH NUMBER
SEE ATTACHED

SCRAP WEARPLATES

DAS
38
9-89

SEP 16 2015

110

QC21- Final Inspection - Work Order Release

0.00

110

QC

Quality Control

Memo

0.00

DAS
27
9-89

SEP 16 2015

54 20150916

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 136047

136047

Parent Item: D350-636-047

D350-636-047

Parent Item Name: Run-on Landing Wearplates Fits LH or RH

Start Date: 8/27/2015

Required Date: 8/28/2015

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV:A 10.09.27 NEW ISSUE DD VERF:EC
Rev:B 11.04.14 ecn11-553 DD verf:EC
PER ECN 11-603 JLM 11.07.07 VERIFIED BY:DD IPP Rev:D 112.04.16
AS PER ECN 12-542 DD verf:EC

IPP

IPP REV:C AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C34A

Purchased

No

Each

18.0000

-2

AN3C34A

BOLT

Location

Loc Qty

Loc Code

ST348

18

m127044

2

m131618

6

m133077

10

JMF 15-9-14

AN3C36A

Purchased

No

Each

338.0000

-8

AN3C36A

Bolt

Location

Loc Qty

Loc Code

FG

47

101261

4

122204

2

m131367

1

m132169

40

FP001

47

m131856

47

ST338a

240

131651

80

m129907

4

m131856

4

m132381

80

m132522

72

ST347

4

m130874

4

JMF 15-9-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

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Page 2

Work Order ID: 136047

136047

Parent Item: D350-636-047

D350-636-047

Parent Item Name: Run-on Landing Wearplates Fits LH or RH

Start Date: 8/27/2015

Required Date: 8/28/2015

Start Qty: 2.00

Required Qty: 2.00

AN3C37A

Purchased

No

Each

479.0000

-2

AN3C37A

BOLT

Location

Loc Qty

Loc Code

ST338a

477

131651

70

M128773

2

M129650

55

M131367

70

M131856

70

M132169

70

M132381

70

M132522

70

ST347

2

129687

2

AN3C42A

Purchased

No

Each

78.0000

-2

AN3C42A

Bolt

Location

Loc Qty

Loc Code

FG

5

121103

5

ST338a

53

m130485

4

m131856

10

m132381

9

m132522

10

m132674

10

m133091

10

ST346

20

m131854

10

m131855

10

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER :									

Picklist Print

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Work Order ID: 136047

136047

Parent Item: D350-636-047

D350-636-047

Parent Item Name: Run-on Landing Wearplates Fits LH or RH

Start Date: 8/27/2015

Required Date: 8/28/2015

Start Qty: 2.00

Required Qty: 2.00

D350-636-047

Manufactured No

Each

0.0000

2

D350-636-047

Run-on Landing Wearplates Fits LH or RH

2x 130718 MF 15-9-14

D3873-1

Manufactured No

Each

66.0000

-16

D3873-1

Bushing

Location

Loc Qty

Loc Code

FP001

44

126709

2

135402

42

ST063

22

129742

16

134883

6

MF 15-9-14

D4170-3

Manufactured No

Each

25.0000

-8

D4170-3

Bushing

Location

Loc Qty

Loc Code

ST096

25

123100

10

135749

3

135922

12

MF 15-9-14

D4171-1

Manufactured No

Each

23.0000

-2

D4171-1

Bushing

Location

Loc Qty

Loc Code

ST096

23

129060

23

MF 15-9-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 136047

136047

Parent Item: D350-636-047

D350-636-047

Parent Item Name: Run-on Landing Wearplates Fits LH or RH

Start Date: 8/27/2015

Required Date: 8/28/2015

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

Each

930.0000

-10

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

11

m130673

11

GA

159

m130673

15

m131677

144

ST304

643

m131340

199

m133031

444

ST308

37

m132551

37

NAS1149C0363R

Purchased

No

Each

1,155.000

-20

NAS1149C0363R

Washer

Location

Loc Qty

Loc Code

FP001

75

114742

75

GA

506

m133077

506

ST260a

494

m133077

494

ST271

80

m130673

20

m1327847

60

Monday, September 14, 2015 2:44:36 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐						OTHER : _____	

LOT TRACKING !!

Parent Item ID /	Reason	Lot Qty	Lot Nbr	Lot Trans Date	Avg Cost Amt
AN3C34A	130718	-2	m127044	3/24/2015 10:52:18 AM	\$4.33
AN3C36A	130718	-4	m131856	3/24/2015 10:52:20 AM	\$9.02
AN3C36A	130718	-4	m129907	3/30/2015 4:33:50 PM	\$9.02
AN3C37A	130718	-2	M128773	3/24/2015 10:52:19 AM	\$5.87
AN3C42A	130718	-2	m130485	3/24/2015 10:52:19 AM	\$9.54
D3873-1	130718	-16	129742	3/24/2015 10:52:18 AM	\$5.88
D4154-041	130718	-2	129058	3/24/2015 10:52:20 AM	\$505.50
D4170-3	130718	-8	123100	3/24/2015 10:52:18 AM	\$17.55
D4171-1	130718	-2	129060	3/24/2015 10:52:18 AM	\$15.04
MS21043-3	130718	-10	m131677	3/24/2015 10:52:19 AM	\$39
NAS1149C0363R	130718	-20	m130673	3/24/2015 10:52:19 AM	\$0.05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

RA 112119 D350-636-047 **B130718**

Received @ Dart July 29th, 2015
Inspected@ Dart July 31st, 2015

CUSTOMER: HELINET AVIATION
CUSTOMER CONTACT: GWEN LASHO
SHIPPED FROM: VAN NUYS CA, USA

Instructions for RA 112119 D350-636-047 B130718 CHG005

- Parts are damaged during shipping
- Both D4151-041 are unrepairable
- Create work order to put all remaining parts in stock and scrap D415~~1~~-041 B129058 x2
- Destroy all paper works

Time Estimate: 2 hours

Departments Required: QC &Stores\Shipping

Pictures Attached: YES (page#2)

QTY INSPECTED: x2 D350-636-047 B130718

**THIS INSTRUCTION SHEET
MUST BE ATTACHED TO THE
RESTOCKING WORK ORDER
AT ALL TIMES!!!!**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -047	Part Number	Description
***43	2	2	2	2		D3493-1	WASHER
*90	1	1	1	1		D4154-041D	WEARPLATE ASSEMBLY
*91A	4	4	4	4		AN3C36A	BOLT
91B	1	1	1	1		AN3G37A	BOLT
91C	1	1	1	1		AN3G42A	BOLT
*92	7	7	7	7		AN960C10	WASHER (OR NAS1148C0363R)
92A			1	1		AN960C10	WASHER (OR NAS1148C0363R)
*93	4	4	4	4		IMS21043-3	NUT
*94	7	7	7	7		D3873-1	BUSHING
94A			1	1		D3873-1	BUSHING
*95	1	1	1	1		D4471-1	BUSHING
96						D4176-3	SPACER
*97	1	1	1	1		AN3C34A	BOLT
*98	2	2	2	2		AN960C10	WASHER (OR NAS1148C0363R)
*99	1	1	1	1		IMS21043-3	NUT

- * PART OF D4168-041/-042/-043/-044
- ** TO BE SUPPLIED BY CUSTOMER
- *** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

- ¹ QTY USED MAY BE LESS ON SKIDTUBES WITH APICAL CYLINDRICAL OR TRI-BAG FLOATS
- ² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH APICAL CYLINDRICAL BAG FLOATS
- ³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH APICAL TRI-BAG FLOATS
- ⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH APICAL TRI-BAG FLOATS